

Work Order ID 150910***150910***

Page 1

Monday, September 12, 2016 10:27:06 AM

Item ID: D2281

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Jack Saddle

Start Date: 9/23/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/8/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 12 2016** Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2281	Rev G

100

0.00

100

Waterjet

FLOW WATER JET

Memo

2.07

FLOW CNC Waterjet

1-Cut as per Dwg D2281 Dwg Rev: **G** Prog Rev: **G** 2-
Deburr if necessary50 EC 16-9-20

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.08

Quality Control

50 EC 16-9-20

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.17

Quality Control

50**DAS**
38
9-89

SEP 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Misidentified ☐	☐	Past Due ☐							

Work Order ID 150910***150910***

Page 3

Monday, September 12, 2016 10:27:06 AM

Item ID: D2281

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Jack Saddle

Start Date: 9/23/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 10/8/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Packaging

Memo

LOCATION : WA001

0.08

SEP 23 2016

DAS
6
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.83

DAS
21
9-89

SEP 23 2016

DAS
21
9-89

SEP 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐					

Picklist Print

Monday, September 12, 2016 10:27:09 AM

Page 1

Work Order ID: 150910

150910

Parent Item: D2281

D2281

Parent Item Name: Jack Saddle

Start Date: 9/23/2016

Required Date: 10/8/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	11.6000	0.125	6.578945			
M304S14GA									**			<i>CL 16-9-21</i>	
304SS sheet .080													

Location

Loc Qty

Loc Code

MAT019

11.6

M129972

5.7

M135061

5.9

135689

x 7

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 150910
Description: Jack Saddle		Part Number: D2281
Inspection Dwg: D2281	Rev: G	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.422	✓			
4.114	+/-0.010	4.112	✓			
2.933	+/-0.010	2.933	✓			
1.535	+/-0.010	1.537	✓			
0.354	+/-0.010	0.352	✓			
0.354	+/-0.010	0.352	✓			
0.604	+/-0.010	0.605	✓			
2.000	+/-0.010	2.005	✓			
3.396	+/-0.010	3.395	✓			
3.646	+/-0.010	3.645	✓			
4.000	+/-0.010	4.007	✓			
1.525	+/-0.010	1.527	✓			
2.475	+/-0.010	2.48	✓			
Ø0.323	+0.006/-0.001	0.327	✓			
0.080	+/-0.010	0.074	✓			

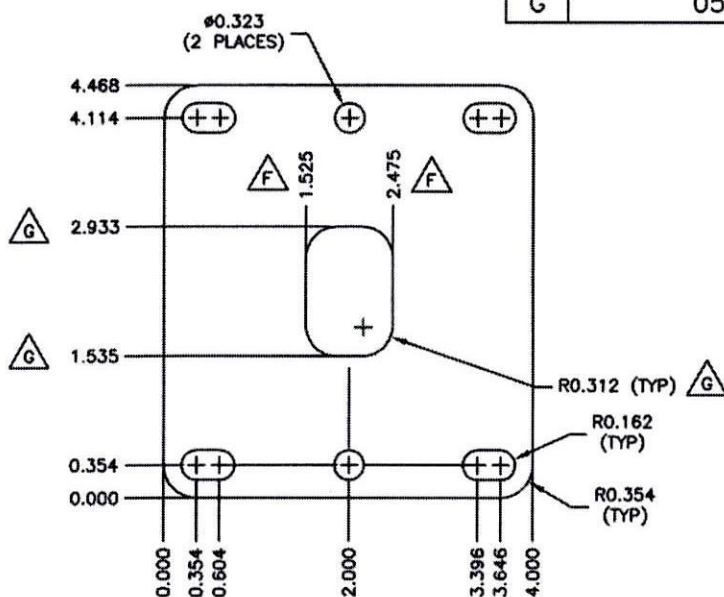
Measured by: EL	Audited by: DAS 38	Prototype Approval: N/A
Date: 16-9-20	Date: SEP 21 2016	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	

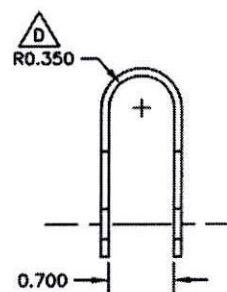
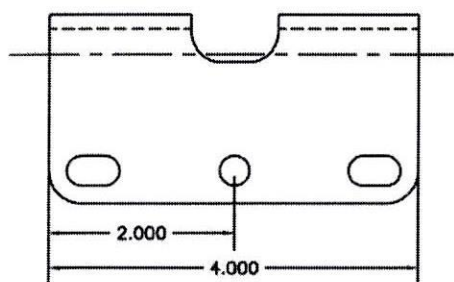


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07	TITLE JACK SADDLE		SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED
[Signature]
05/08/11



FLAT LAYOUT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150910 M25
1609-12

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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